














Date: Tuesday, 9/4/2007 11:29:25 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : INLET VALVE SHAFT
Job Number : 34391	
Estimate Number : 12251	
P.O. Number : N/A	Part Number : D34745
This Issue : 9/4/2007 S.O. No. : N/A	Drawing Number : D3474 REV.A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 29457	Material : N/A
Written By : <u> </u>	Due Date : 10/4/2007 Qty: 6 Um: Each
Checked & Approved By : <u> </u>	
Comment : est rev. A 06.04.20 New issue EC	
Additional Product	
Job Number: 	
Seq. #:	Machine Or Operation: Description :
1.0	M304S26GA 304/316 0.018 SHEET
 	
Comment: Qty.: 0.0525 sf(s)/Unit Total : 0.3150 sf(s) 304/316 0.018 SHEET M10S490 HB 07-09-06	
2.0	WATER JET FLOW WATER JET
 	
Comment: FLOW WATER JET Cut as per Dwg D HB 07-09-06 Dwg Rev: A Prog Rev: A (6)	
3.0	QC2 INSPECT PARTS AS THEY COME OFF MACHINE
 	
Comment: INSPECT PARTS AS THEY COME OFF MACHINE HB 07-09-06	
4.0	QC8 SECOND CHECK
 	
Comment: SECOND CHECK HB 07-09-06 (X6) counter	
5.0	SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1
 	
Comment: SMALL & MEDIUM FAB RESOURCE 1 Debur if necessary. SAO 07/09/06 (6)	
6.0	QC5 INSPECT WORK TO CURRENT STEP
 	
Comment: INSPECT WORK TO CURRENT STEP SB 07/09/11	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 01/09/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 9/4/2007 11:29:25 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: INLET VALVE SHAFT

Job Number: 34391

Part Number: D34745

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: St 100

EP 07/09/11 (6)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

EP 07/09/11 (6)

Job Completion



U 07-09-11

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

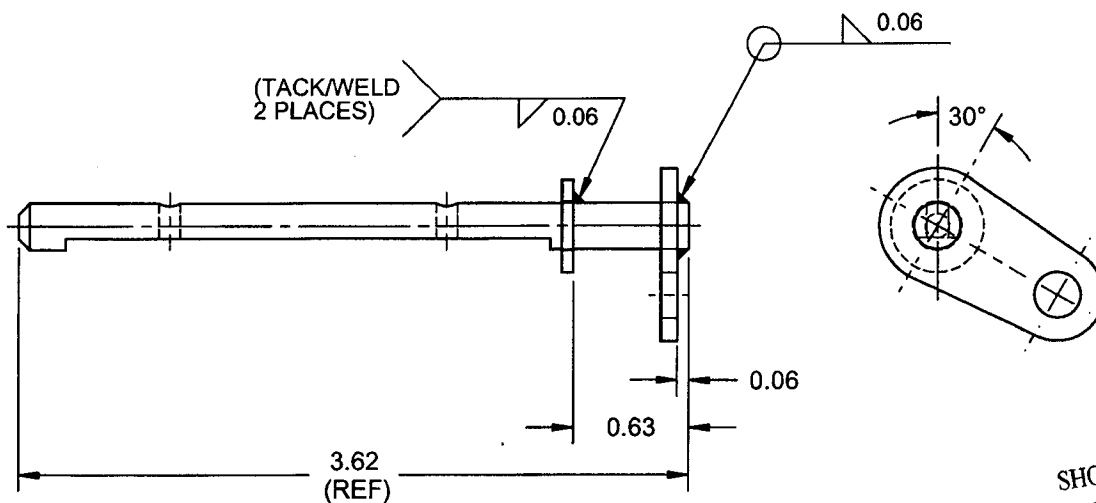
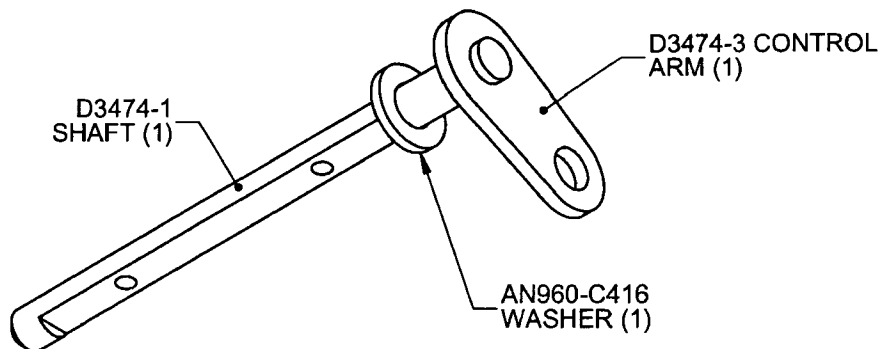
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3474	REV. A SHEET 1 OF 4
DATE 06.01.23		TITLE INLET VALVE SHAFT	SCALE 1:1
A	06.01.23	NEW ISSUE	

[Signature] 06.04.03**D3474-041 INLET VALVE SHAFT**

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WORK ORDER
NO. *34391*

NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

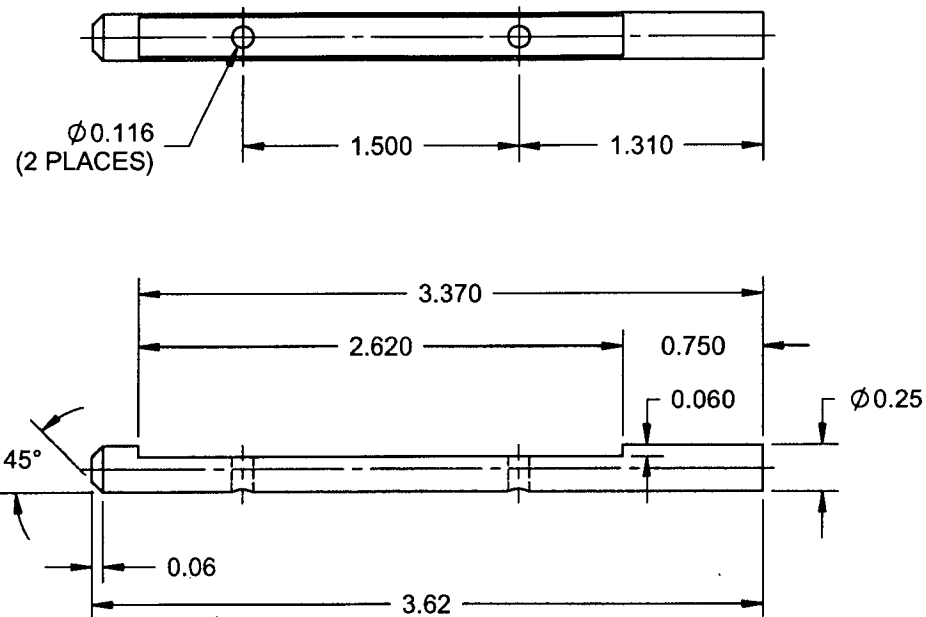
QTY -041	P/N	DESCRIPTION
X	D3474-041	INLET VALVE SHAFT
1	D3474-1	SHAFT
1	D3474-3	CONTROL ARM
1	AN960-C416	WASHER

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DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3474	REV. A SHEET 2 OF 4
DATE 06.01.23		TITLE INLET VALVE SHAFT	SCALE 1:1

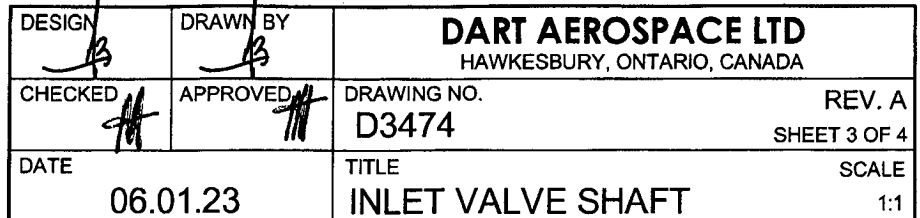
[Signature] 06-04-03**D3474-1 SHAFT****NOTES:**

- 1) MATERIAL: AISI 303 STAINLESS STEEL 0.25 ROUND BAR
(REF. DART SPEC. M303R0.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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Technical drawing of a vertical rectangular plate. The drawing shows a side view of the plate with a vertical dimension line on the right indicating a height of 1.31 (REF). A horizontal dimension line at the bottom indicates a width of 0.09 (REF). The plate has a central vertical slot and two horizontal slots near the top and bottom.

Technical drawing of a circular part. The drawing shows a circle with a center point marked with a cross. Dimensions are given in inches:

- Overall width: 1.500
- Distance from center to the left edge: 0.750
- Overall height: 1.450
- Overall width including mounting holes: 2.580
- Distance from the left edge to the center of the mounting hole: 1.450
- Distance from the center of the mounting hole to the center of the circle: 0.750
- Distance from the center of the circle to the right edge: 0.750
- Distance from the center of the circle to the right edge of the mounting hole: 1.450
- Distance from the center of the circle to the right edge of the mounting hole: 1.450

Labels and notes:

- $\varnothing 0.116$ (2 PLACES) with arrows pointing to the two mounting holes.
- LVE** (Large Vertical Error)
- E** (Error)
- C.** (Correction)

0.018
(REF)

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34391

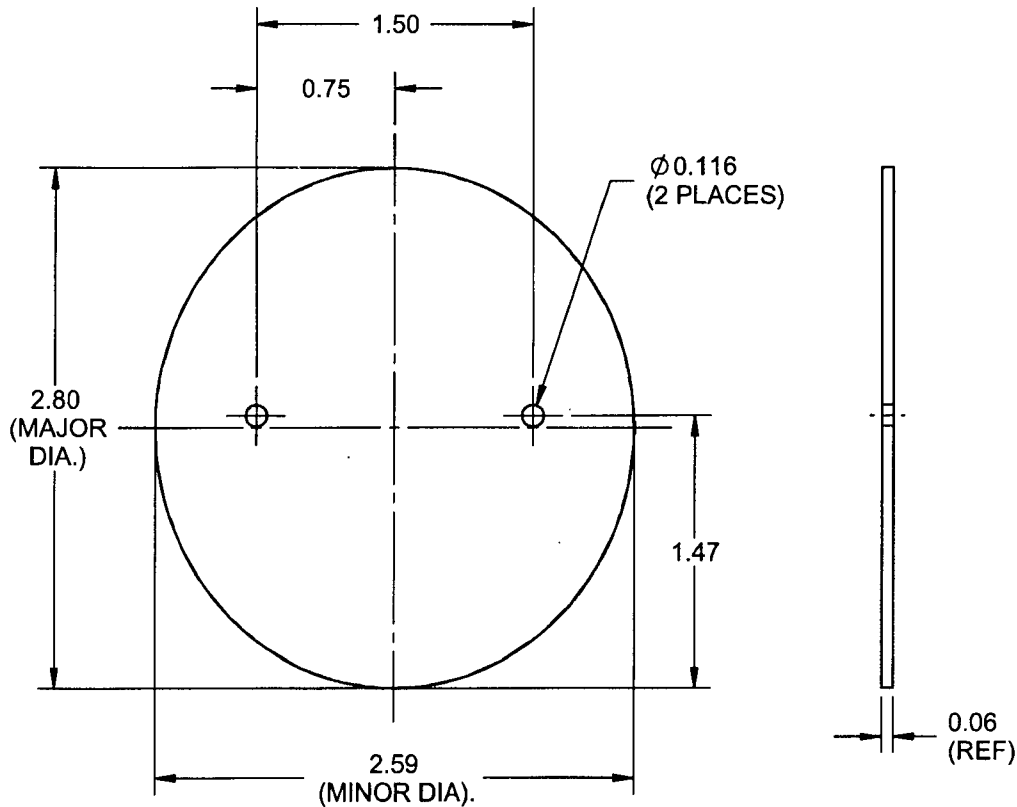
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[illegible]

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DESIGN B	DRAWN BY B	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3474	REV. A SHEET 4 OF 4
DATE 06.01.23		TITLE INLET VALVE SHAFT	SCALE 1:1

H 06.04.03

**D3474-7 BUTTERFLY VALVE SEAL****NOTES:**

- 1) MATERIAL: RED (OR GRAY) 60 DUROMETER HI-TEMPERATURE SILICONE SHEET, 0.063 THICK (REF. DART SPEC. M-SIL60-S.063)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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